

CENTRAL INTELLIGENCE AGENCY
INFORMATION REPORT

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COUNTRY	Czechoslovakia	REPORT	
SUBJECT	Production of Acetylene Cutting Equipment at the Chotebor Metal Works, Chotebor	DATE DISTR.	5 October 1954
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		REFERENCES	

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This is UNEVALUATED

THE SOURCE EVALUATIONS IN THIS REPORT ARE DEFINITIVE.
 THE APPRAISAL OF CONTENT IS TENTATIVE.
 (FOR KEY SEE REVERSE)

1. The first series of the new cutting equipment R-1 was completed at the Chotebor Works at about May 1952. The first set was sent to the Kralovo Pole Plant of the Gottwald Works² in Brno-Kralovo Pole for testing. The results were excellent and the new machine replaced hand-operating cutting equipment which was rather slow and inaccurate.
2. The mechanism is in an aluminum case, 300 x 500 x 150 mm., which moves on rails of 0.28-meter gauge. In the center of the top of the case is a protruding arm (No. 2 on diagram). It is a tube, 45 mm. in diameter, with a gas-regulating tap on one end (No. 3) and with the cutting tap on the other (No. 4). The flow of gas can be regulated by means of two taps on the cutter, where the rubber tubes open into the cutter (No. 5). The cutter can be adjusted to various positions and the torch tip can be fixed according to the thickness of the steel sheets (No. 6). An electric switch (No. 7) is on the top of the case (220 V). Next to it is the speedometer showing the output of the machine per minute (No. 8). On the other side of the switch is the speed-control button (No. 9) by which speed of moving along the rails can be regulated. A reverse button (No. 1) is on the edge. On the front part is a holder, into which an arm is fixed, permitting a circular movement of the cutting machine outside the rails.
3. The machine operates on the principle of acetylene and oxygen cutters. The mixture can be adapted to a required pressure according to the thickness of the steel. The principle of acetylene welding remained unchanged, only the process has been changed. The new cutting equipment moves on rails and is suitable for cutting sheets of any length. The process is faster and more accurate than that of hand-operated machines. No further machining of the cut pieces is necessary. The machine can also be taken off the rails in which case a support is fixed to the front part, enabling circular movement of the machine. Weight is about 10 kg. Cutting may continue without interruption until the oxygen and acetylene bottles have to be changed.

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(NOTE: Washington distribution indicated by "X"; Field distribution by "#".)

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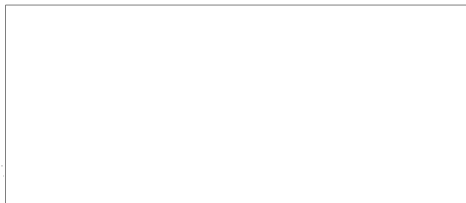
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4. This equipment is used for cutting sheets of major length, and from 30 to 100 mm. thick. Oxygen pressure removes parts of red-hot metal so that the cut is completely clean.

Comments:

1. Probably identical with the plant listed in the Pardubice telephone directory 1951-52 as the Chotebor Metal Works (Choteborske kovodelne zavody), National Enterprise, in Chotebor.

2. Now known as the Brno-Kralovo Pole Plant of the First Brno and Kralovo Pole Machine Works, Gottwald Works (Prvni brnenska a kralovopolska strojirna, Gottwaldovy zavody), National Enterprise.



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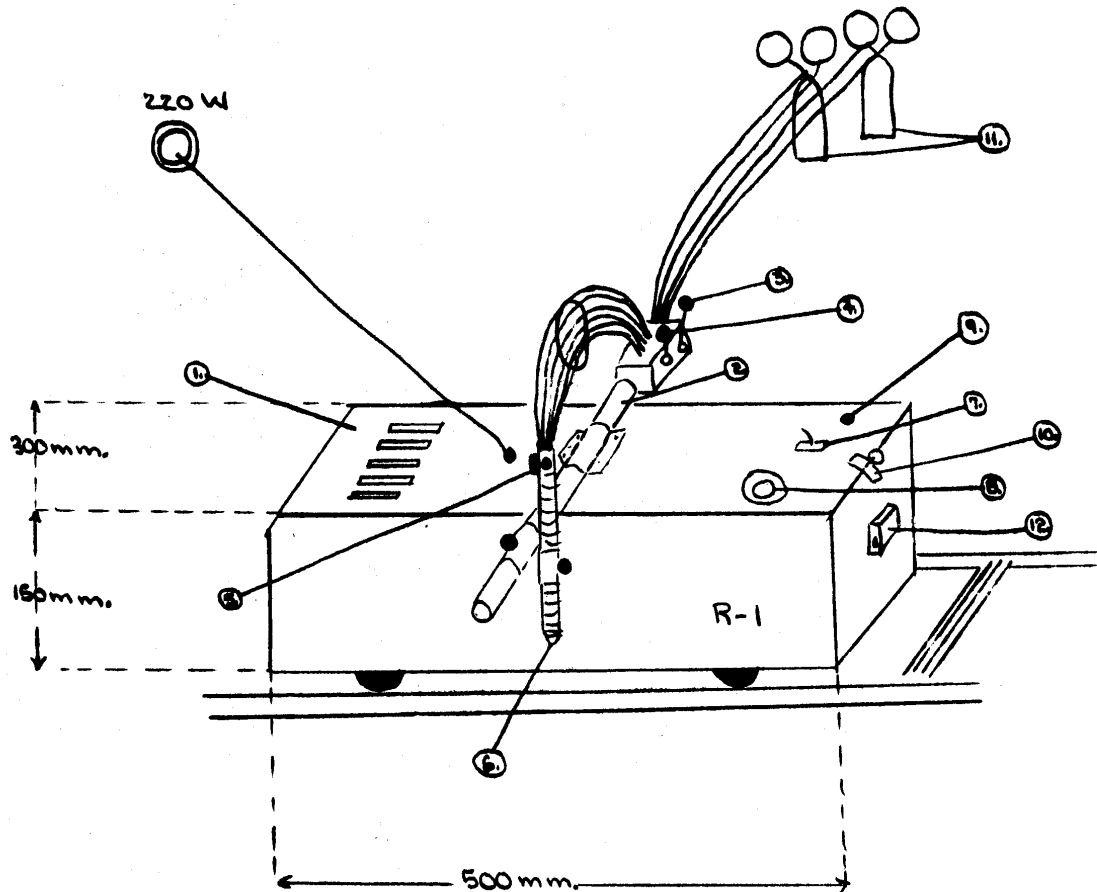
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Legend:

1. Aluminum case.
2. Arm supporting the cutter.
3. Gas-regulating tap.
4. Cutting regulating tap.
5. Taps for regulating the cutter.
6. Cutter.
7. Electric switch.
8. Cutting speedometer.
9. Speed-control button.
10. Reverse button.
11. Oxygen and acetylene bottles.
12. Support for circular cutting.
13. Rails, 0.28-meter gauge.

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